

54405 Nerev

Work Order ID 53781



Page 1

November 18, 2009 12:38:42 PM

Item ID: D2230-3

Accept



Setup Start

Revision ID: *16*

Stop



Item Name: Lug

Start Date: 18/11/2009 Start Qty: 120.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 120.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *PL*Date: *09/11/18*

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2230

Rev F

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Band Saw ☐ Cut D2423 extrusion to 0.82" ☐ Batch: *43722**OK 09/11/22**120*

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Machine per folio D2230-3 ☐ Check for crack while loading into the machine.*OK 09/12/01*
*DJP 09/12/03**120*

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

OK 09/12/01
*DJP 09/12/03**120*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53781

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Item ID: D2230-3

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 18/11/2009 Start Qty: 120.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 120.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

BL 09-12-7

120



QC

Memo

0.00

Quality Control

170

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

M112418

BL 09-12-7

120



Powdercoat

Memo

0.00

Powder Coating

START TIME: *12:00*

OVEN TEMPERATURE:

320° FINISH TIME

12:30

180

QC3- Inspect Part Finish

0.00

=> M 09/12/09

120



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53781

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Page 4

Item ID: D2230-3

Accept



Setup Start



Revision ID: F

Stop



Item Name: Lug

Start Date: 18/11/2009 Start Qty: 120.00



Cust Item ID:

Required Date: 25/11/2009 Req'd Qty: 120.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

Identify as per dwg & Stock Location: 31476 0.00

MO 09/12/08



Packaging

Memo

0.00

1120

Packaging

200

QC21- Final Inspection - Work Order Release 0.00



QC

Memo

0.00

Quality Control

09/12/09

MF 09-12-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 18, 2009 12:38:48 PM

Page 1

Work Order ID: 53781

Parent Item: D2230-3RevF

Parent Item Name: Lug

Comments:

Start Date: 18/11/2009

Required Date: 25/11/2009

Start Qty: 120.00

Required Qty: 120.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2230-3PRevF		Purchased	No			100	Each	0.0000	120.0000			
LUG												
D2423RevB1		Manufactured	No			100	f	658.2039	8.6274			
Lug Extrusion												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

658.2039221

43722

207.263091

44529

22.39

45800

428.550832

8.6274 m 09/11/22

Dart Aerospace Ltd

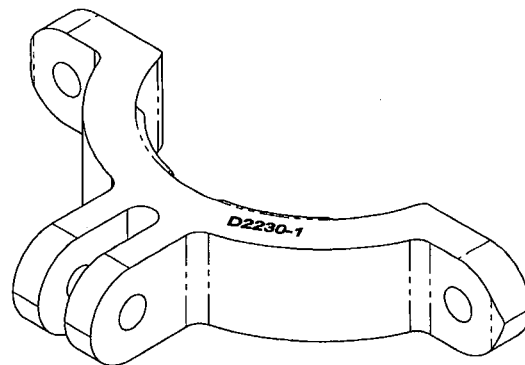
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

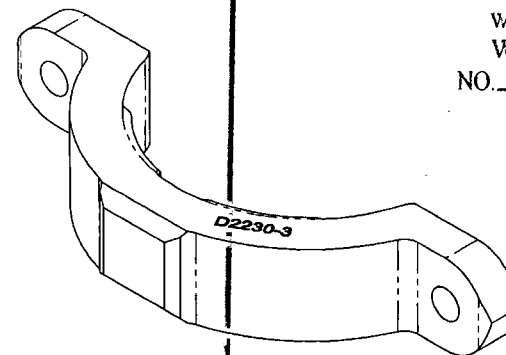
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2230-1 MOUNTING LUG



D2230-3 MOUNTING LUG

SHOP COPY
RETURNED
ENGINEER
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER NO. 53781
DPO9-1118

RELEASED
01/06/2011

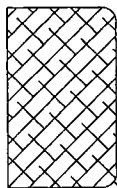


NOTES:

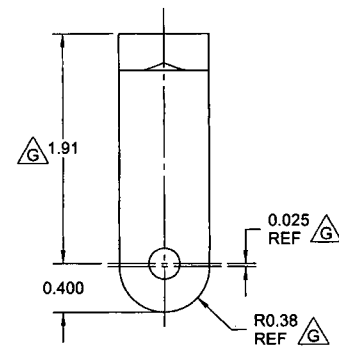
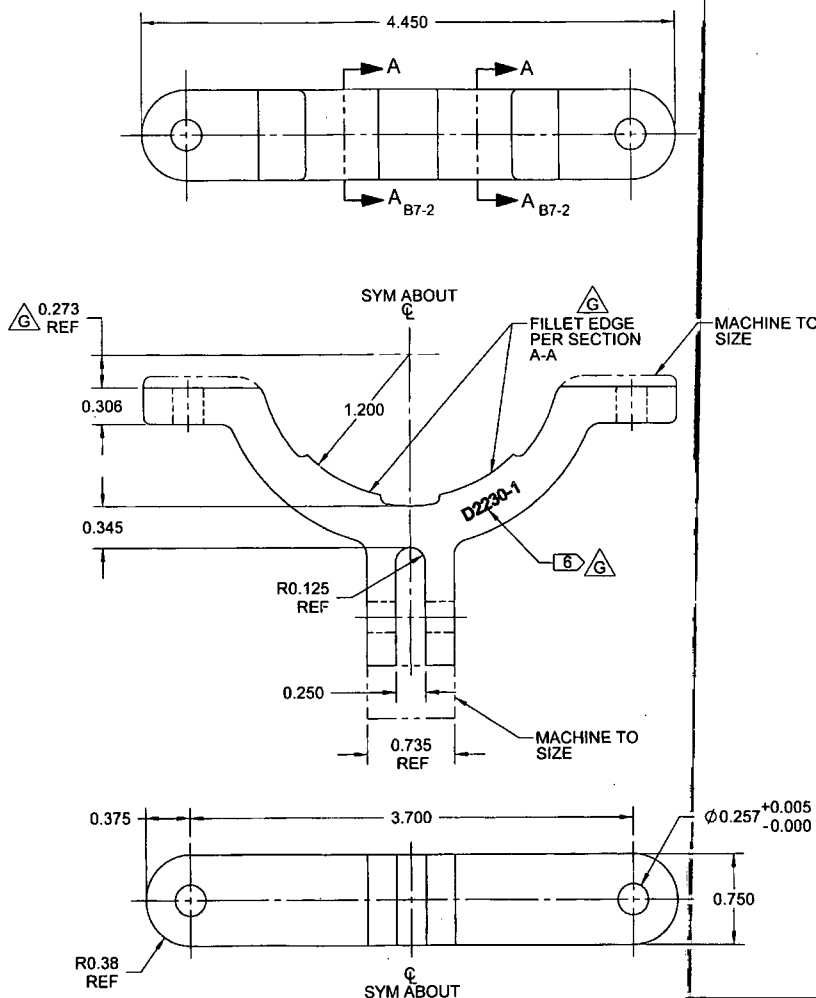
- 1) MATERIAL: MAKE FROM D2423 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER TO A DEPTH OF 0.010 ± 0.005 IN THIS LOCATION, WITH TOOL TIP RADIUS OF 0.015 ± 0.005.
- 7) WEIGHT: -1: 0.16 lbs
-3: 0.14 lbs

I	G	REDRAWN IN SOLIDWORKS TO CURRENT DESIGN STANDARDS. REFER TO SECTION A-A & B-B FILLET ADDED TO PREVENT CHAFING OF RUBBER CUSHION ON INSTALLATION.	AJS	09.01.16
	F	REDESIGN; R1.200 WAS 1.100	CP	99.12.13
	E	RE-DESIGN	BW	95.01.04
	D	RE-DESIGN	BW	95.01.04
	C	RE-DESIGN	BW	94.03.30
REV.		DESCRIPTION	BY	DATE
DESIGN		BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		AJS		
CHECKED		<i>[Signature]</i>	DRAWING NO.	REV. G
MFG. APPR.		<i>[Signature]</i>	D2230	SHEET 1 OF 3
APPROVED		<i>[Signature]</i>	TITLE	SCALE
DE APPR.		<i>[Signature]</i>	MOUNTING LUG	NTS
DATE		09.01.16	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

SECTION A-A D4-2
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



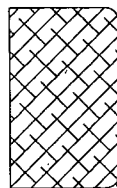
D2230-1 MOUNTING LUG

RELEASED
09/06/25 M

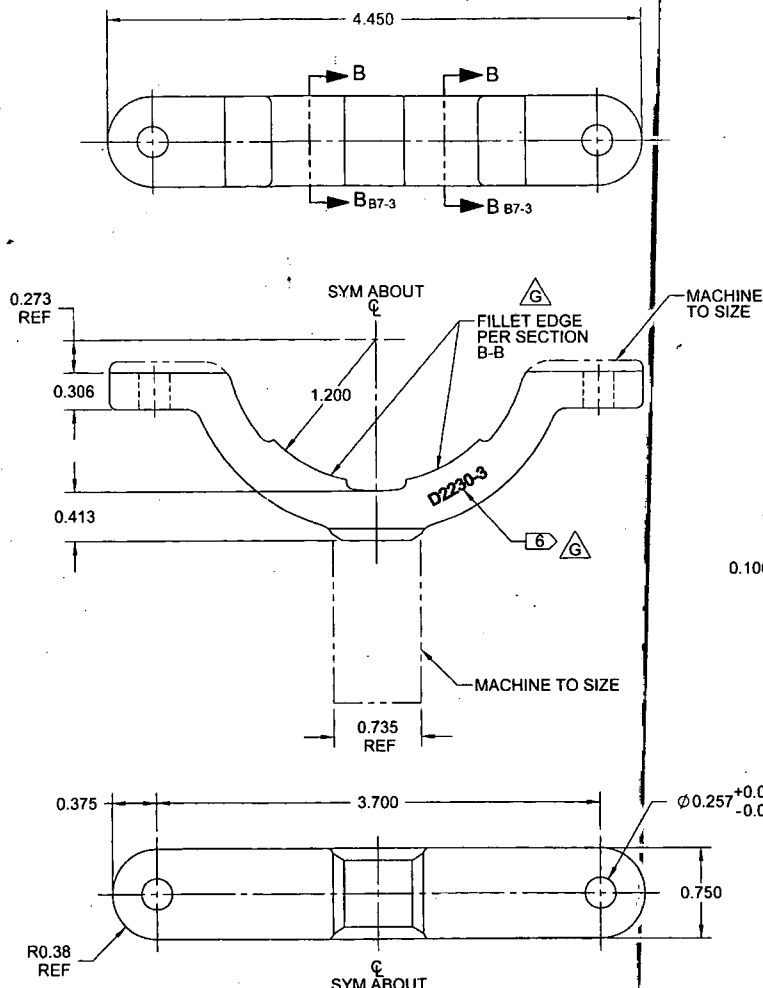
W/0 53781

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		MOUNTING LUG	NTS
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SECTION B-B D4-3
SCALE 2X



R0.06 MIN - R0.10 MAX
2 PL



D2230-3 MOUNTING LUG

RELEASED
09/06/25

W/10 5375

DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2230	SHEET 3 OF 3
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